

Date: Wednesday, 2/20/2008 4:23:43 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HANDLE WELDMENT		
Job Number	: 37546					
Estimate Number	: 10333					
P.O. Number	: 1			Part Number	: D2530	
This Issue	: 2/20/2008	S.O. No.	:	Drawing Number	: D2530 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /	Type	: SMALL /MED FAB	Drawing Revision	: B	
Previous Run	: 36657			Material	:	
Written By	:			Due Date	: 3/10/2008	
Checked & Approved By	: <u>JM</u> 02/21			Qty:	20	Um: Each
Comment	: Est Rev:E Removed Purchasing 05-11-07 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 3.0602 f(s)/Unit Total : 61.2045 f(s) Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049) Batch: <u>M107099(3x)</u> <u>M107098(7x)</u>	
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1  1-Cut to length as per Dwg D2530  2-Deburr	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
4.0	D2534	Lock Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: QTY Part # Description Batch	
	2	D2534 Lock Plate	<u>537563</u> ✓
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1  1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301 ✓  2-Deburr ✓	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 37546		Part Number: D2530
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC9	VISUAL WELDING INSPECTION 
7.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: VISUAL WELDING INSPECTION		<i>100% 08/04/08 (20)</i>
Comment: INSPECT WORK TO CURRENT STEP		<i>100% 08/04/08 (20)</i>
8.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3		<i>100% 08/04/08 (20)</i>
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>100% 08/04/08 (20)</i>
10.0	PACKAGING 1	PACKAGING RESOURCE # 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST204		<i>08/04/08 (20)</i>
11.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		<i>08/04/08 (20)</i>
Job Completion		 <i>mf 08-04-08.</i> <i>w</i>

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

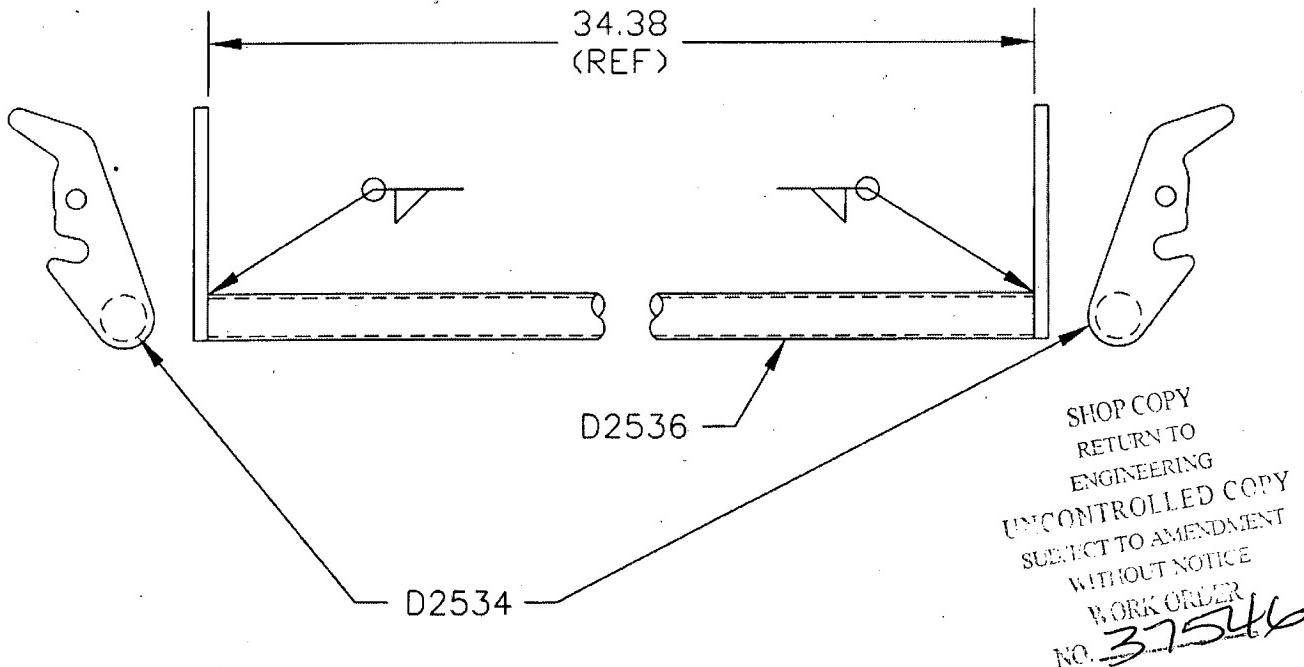
**DART**

DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2530	REV. B SHEET 1 OF 1
DATE 04.12.14	TITLE HANDLE WELDMENT		SCALE
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *[Signature]*PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED